

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000461**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 19-Nov-2007**Location:** Changxing Island, Shanghai, China

Submittals(New / Total): **CWR's:** 0 / 47 **HSR's:** 0 / 10 **NCR's:** 0 / 13

Item	Title	Detail
1	Other important observations	At approximately 0830 hours I went on a shop walkthrough with Pete Siegenthaler, Jason Tom, Keith Devonport, and Alistair Melville. During the walkthrough we observed the following: 1) The closed rib weld trial where we noted that the mastic had been applied for future leak testing 2) tower mock-up fabrication where we witnessed ZPMC working on the longitudinal stiffener welds for the 89-m mock-up 3) plate cutting for the OBG bottom plate T-stiffener diaphragms.
2	Meetings attended	At 1000 hours I attended the Fabrication Update Brief. The following were the highlights of the discussion: 1) Closed Rib UT Procedure: this must be completed before the weld trials can move forward, ABF/ZPMC has received the calibration blocks and METS estimated a minimum of 3 weeks until the UT Procedure was ready. 2) Closed Rib Weld Trials: ABF and CT to meet today to discuss a path forward regarding the differences found between the METS inspection of the weld trial and the ABF/ZPMC inspection. This meeting will be today at 1230 hours. 3) Deck Panel Fabrication: Construction is concerned that ZPMC is not using the template to check the T-stiffeners; this will be addressed in the issues with ABF meeting this afternoon. 4) Tower Mock-Up: It was discussed that ZPMC may not be following the Fabrication and Welding Sequence for welding the longitudinal stiffeners after they made modifications to their welding procedure. This will be addressed in the issues meeting with ABF this afternoon.
3	Meetings attended	At 1230 hours I attended the meeting to discuss the Closed Rib Weld Trial inspection results. Meeting attendees were: Dave Williams, Peter Ferguson, Keith Devonport, Jason Tom, Art Peterson, Craig Knops, Pete Siegenthaler, and David McClary. ABF stated they believe that ABF and CT agree regarding the definition and method of measurement of all defects other than overlap; however, there are some differences in opinion regarding how the lengths of the defects were measured. ABF is currently putting their data in the same format as the CT data in order to more easily do a

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comparative analysis between the two sets of data. ABF and CT also agreed to cut and macro-etch one of the welds to possible help resolve the dispute regarding “overlap” versus “excessive convexity”. The samples will be selected tomorrow with both ABF and CT present. CT stated they would like to have the macro-etch samples ready so the group could meet to discuss them as soon as possible (CT wanted to meet before next Monday).

4 Meetings attended

At 1330 hours I attended the Daily Issues Meeting. The meeting attendees were numerous and have been recorded in the meeting minutes by METS. The following items were discussed: 1) ZPMC requested a green tag inspection of the OBG flange plates to Wuxi in order to be heated and bent; ZPMC indicated this material would not be bent at Changxing Island 2) ZPMC asked about 3 new CWR's for base metal cracks on the OBG T-stiffener welds; CT stated they had not received these CWR's as of this date, ABF to look into why these have not been transmitted to the Department 3) ZPMC stated they have SPCM material (OBG bottom plate – 22mm) which is being used in production but has not been check sampled and tested. After a long discussion, ZPMC stated they have 2 more plates from the same heat and thickness which have not been cut and requested to take the check samples from these plates. METS agreed this would be appropriate and would need to verify the heat numbers of the cut plates and raw plates, 4) CT asked about the schedule for the machining of the 89-m diaphragm assembly, ZPMC did not know during the meeting but indicated they would forward this information to CT tomorrow.

Inspected By: Smith,Ryan

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
